

Date: Wednesday, 8/15/2007 6:18:13 AM  
User: Jean-Luc Menard

# Process Sheet

|                       |  |                  |                 |
|-----------------------|--|------------------|-----------------|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : LATCH BRACKET |
| Job Number            | : 33893  |                  |                 |
| Estimate Number       | : 10994  |                  |                 |
| P.O. Number           | : N/A  | Part Number      | : D2583         |
| This Issue            | : 8/15/2007 S.O. No. : N/A   | Drawing Number   | : D2583 REV. B  |
| Prsht Rev.            | : NC   | Project Number   | : N/A           |
| First Issue           | : N/A  | Drawing Revision | : B             |
| Previous Run          | : 30716  | Material         | : N/A           |
| Written By            | : <u>ML 07-08-15</u>   | Due Date         | : 8/22/2007     |
| Checked & Approved By | :  | Qty:             | 50 Um: Each     |
| Comment               | Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM<br>Est: D 06.07.21 Waterjet EC |                  |                 |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |              |                    |
|-----|--------------|--------------------|
| 1.0 | M5052H32S040 | 5052-H32 040 Sheet |
|-----|--------------|--------------------|



Comment: Qty.: 0.1227 sf(s)/Unit Total : 6.1373 sf(s)  
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick  
 (M5052H32S040) Batch: ML04921 IB 07-08-15

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2583  
 Dwg Rev: B IB 07-08-15  
 Prog Rev: B  
 2-Deburr if necessary

(51)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-08-15

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

En 57/08/15

Coater  
(X51)

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE  
 Deburr  
 Form on CNC Brake as per Dwg D2583

ml 07/08/20 (x51)

S/S 07/08/21 (51)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 33893

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

En 07/09/03 (X57)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ET 07-08-25

(51)

8.0

POWDER COATING

POWDER COATING



M105068



(51X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h 07/08/29

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/29 (51)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/08/29 (54)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(51)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/30

Job Completion



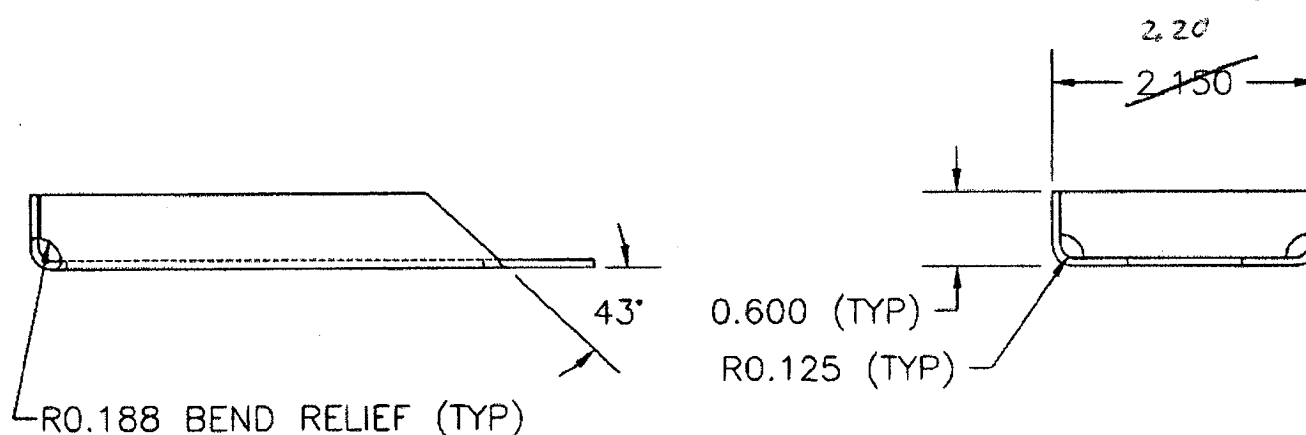
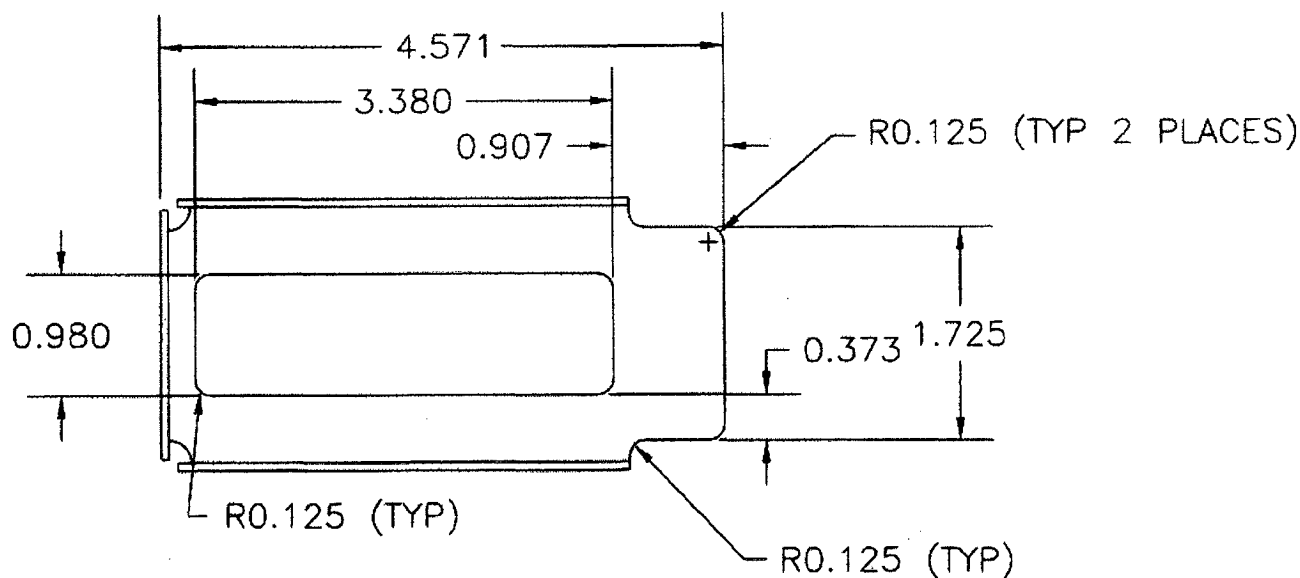
U 07-08-30





RELEASED  
KE 99.02.25

|         |          |                                 |               |                             |
|---------|----------|---------------------------------|---------------|-----------------------------|
| DESIGN  | MIKE M.  | DRAWN BY                        | RF            | DART AEROSPACE LTD          |
| CHECKED | CP       | APPROVED                        | KE            | HAMKESBURY, ONTARIO, CANADA |
| DATE    | 99.02.22 | TITLE                           | LATCH BRACKET | REV. B                      |
|         |          | DRAWING NO.                     | D2583         | SHEET 1 OF 1                |
|         |          | SCALE                           | 2:3           |                             |
| A       | 96.07.10 | NEW ISSUE                       |               |                             |
| B       | 99.02.22 | CHANGE OF FINISH (PER TSR A887) |               |                             |



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED